

# Work Order ID 73226

Friday, August 26, 2011 10:27:12 AM



Page 1

Item ID: D3315-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 8/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/08/20 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3315

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D. ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-Debur if necessary

1010 103

B11-8-30

⑦

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-8-30

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sublog/30

⑦

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73226

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Page 2

Item ID: D3315-2

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Stop



Item Name: Wearplate

Start Date: 8/26/2011 Start Qty: 6.00



Cust Item ID:

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Customer:

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Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
140 	NC BRAKE	0.00							
Brake NC	Memo	0.00							
Brake NC	1- Form using DT8751 Die as per Dwg D3315 Rev: <u>B</u> 2- Form using DT8179 Die and form joggle using DT8157 as per Dwg D3315 Rev: <u>B</u>								
150 	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									

SP 11/09/02 SP 11/09/01

Sub 11/09/06

(+2)

-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73226

Friday, August 26, 2011 10:27:12 AM



Item ID: D3315-2	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Wearplate					
Start Date: 8/26/2011	Start Qty: 6.00		Cust Item ID:		
Required Date: 9/9/2011	Req'd Qty: 6.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Large Fab	0.00							
Large Fab	Memo	0.00				X7	11-09-08	JAL	
Large Fab	Weld hard surface using D3315-2T3 as per QSI 004 and Dwg D3315 Rev: <input type="checkbox"/> Qty Part Number Description Batch <input type="checkbox"/> A/R N/A 7560 Hardcoat Rod M117741								
170 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									
180 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

S. 10/26/07

S. 10/26/07

(47)  
-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Friday, August 26, 2011 10:27:12 AM



Page 4

Item ID: D3315-2	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Wearplate					
Start Date: 8/26/2011	Start Qty: 6.00		Cust Item ID:		
Required Date: 9/9/2011	Req'd Qty: 6.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
<div style="display: flex; justify-content: space-between;"> <div> <p><i>M 117338</i></p> <p>QC3- Inspect Part Finish</p> </div> <div> <p>Memo</p> <p>START TIME: <i>8:50</i></p> <p>FINISH TIME: <i>9:20</i></p> </div> <div> <p>0.00</p> <p>OVEN TEMPERATURE:</p> </div> </div>									
200  QC Quality Control		0.00							
<div style="display: flex; justify-content: space-between;"> <div> <p>QC</p> </div> <div> <p>Memo</p> <p>Identify on inside surface using a permanent fine point marker with the following: <input type="checkbox"/> TCCA-PDA, Dart Aerospace Ltd. <input type="checkbox"/> P/N: D3315-2, B/N: BXXXXX <input type="checkbox"/> For Product Eligibility see PDA04-17 <input type="checkbox"/> and Stock <input type="checkbox"/> Location: <i>ST 496</i></p> </div> <div> <p>0.00</p> </div> </div>									
210  Packaging Packaging	Packaging	0.00							
<div style="display: flex; justify-content: space-between;"> <div> <p>Packaging</p> </div> <div> <p>Memo</p> </div> <div> <p>0.00</p> </div> </div>									

*TX M-11/09/14*

*COUNTED & MEASURED*  
*7* *11-09-14*

*(7X) 11-09-14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 73226**

Page 5

Friday, August 26, 2011 10:27:12 AM

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Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 8/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/15  
MF  
11-09-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, August 26, 2011 10:27:10 AM

Work Order ID: 73226



Parent Item: D3315-2



Parent Item Name: Wearplate

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: A 05.05.12 New issue KJ/JLM  
IPP Rev:B As per Rev B 06-03-24 JLM  
IPP RevC now water jet 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary** Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	-----------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M1010S16GA

Purchased

No

100

sf

134.3000

1.695

10.17

td



B11-8-30

1010/1025 sheet 16GA

Location

Loc Qty

Loc Code

MAT019

134.3

116791

32.5

117500

101.8

117500

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	73226
<b>Description: Wearplate</b>		<b>Part Number:</b>	D3315-2
<b>Inspection Dwg: D3315</b>		<b>Rev: B</b>	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.266 x 0.450	+0.006/-0.001 x +/-0.010	266X 453	✓		V HB02	
4.402	+/-0.010	4.400	✓		V	
4.137	+/-0.010	4.137	✓		V	
3.550	+/-0.010	3.555	✓		V	
5.464	+/-0.010	5.468	✓		V	
5.214	+/-0.010	5.214	✓		V	
1.224	+/-0.010	1.226	✓		V	
2.57	+/-0.030	2.579	✓		V	
6.273	+/-0.010	6.270	✓		V	
8.224	+/-0.010	8.227	✓		PROW502	
9.515	+/-0.010	9.519	✓		P	
11.429	+/-0.010	11.426	✓		P	
15.474	+/-0.010	15.474	✓		T HB01	
16.379	+/-0.010	16.379	✓		T	
21.360	+/-0.010	21.360	✓		T	
23.474	+/-0.010	23.474	✓		T	
26.273	+/-0.010	26.273	✓		T	
29.42	+/-0.030	29.42	✓		T	
0.060	+/-0.010	.063	✓		V	
Ø0.300	+0.006/-0.001	.0302	✓		V	

<b>Measured by:</b> KB	<b>Audited by:</b> J	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-8-30	<b>Date:</b> 11/04/30	<b>Date:</b>	N/A

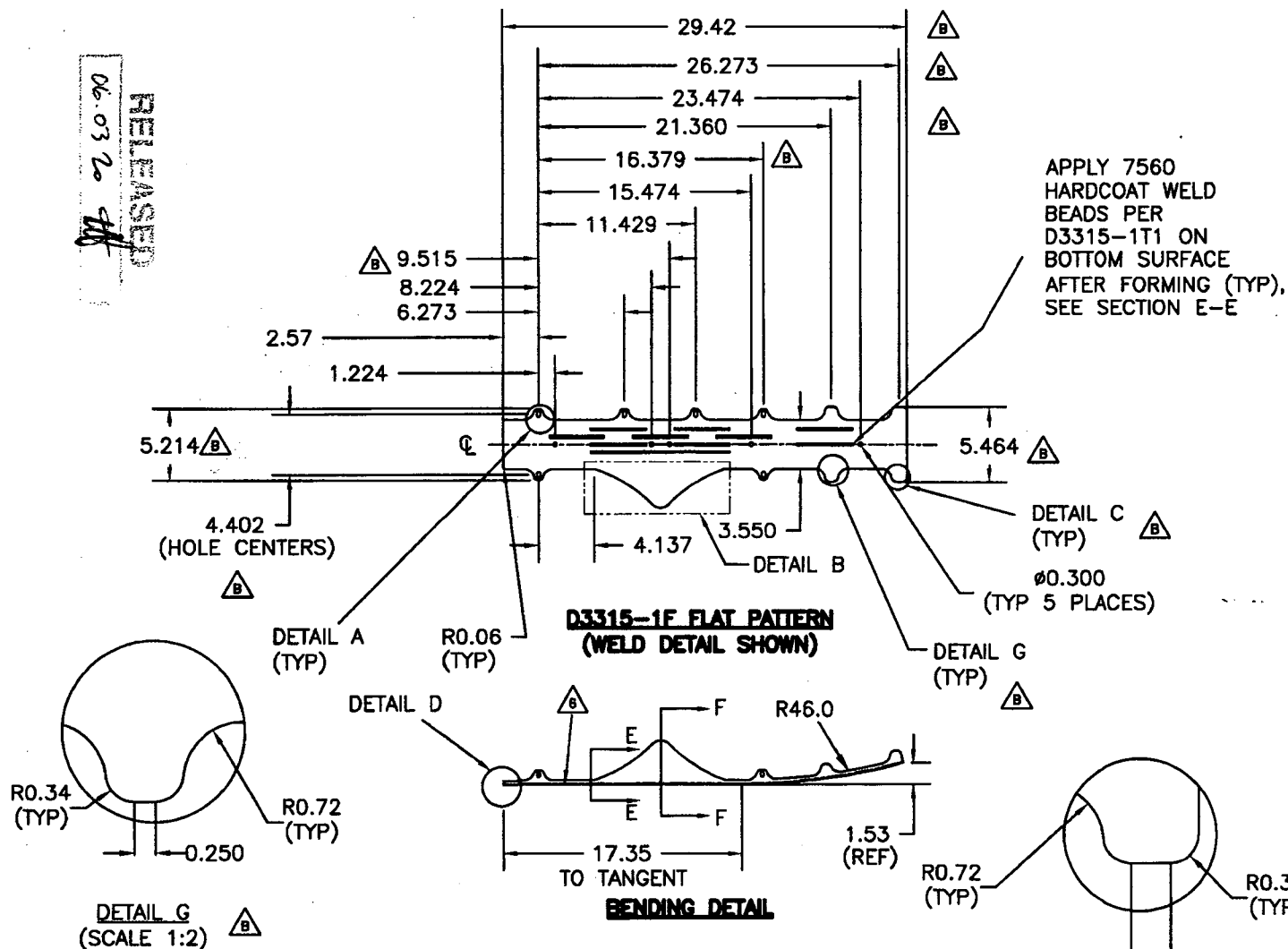
Rev	Date	Change	Revised by	Approved
A	09.09.28	New Issue	KJ	



**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD
84	84	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3315
DATE	TITLE	SCALE
06.01.31	WEARPLATE	1:12
A	B	REVISIONS
04.09.10	06.01.31	NEW ISSUE
		UPDATE DIMENSIONS

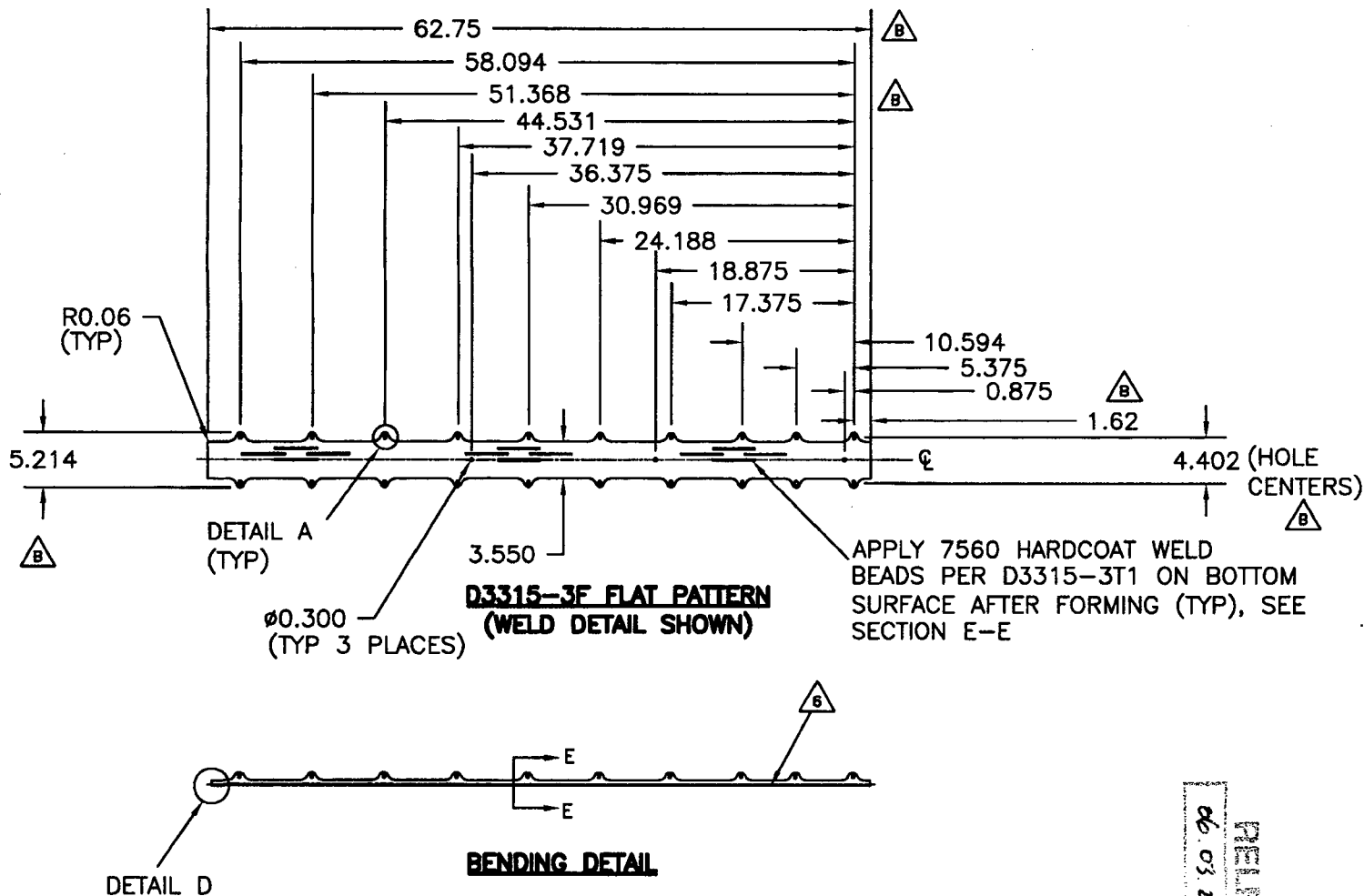
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06.03.20 *[Signature]*



**D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
  - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
  - 3) WELD PER DART QSI 004
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- "TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 73226  
C/L 1/08/26

**DART**

**D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

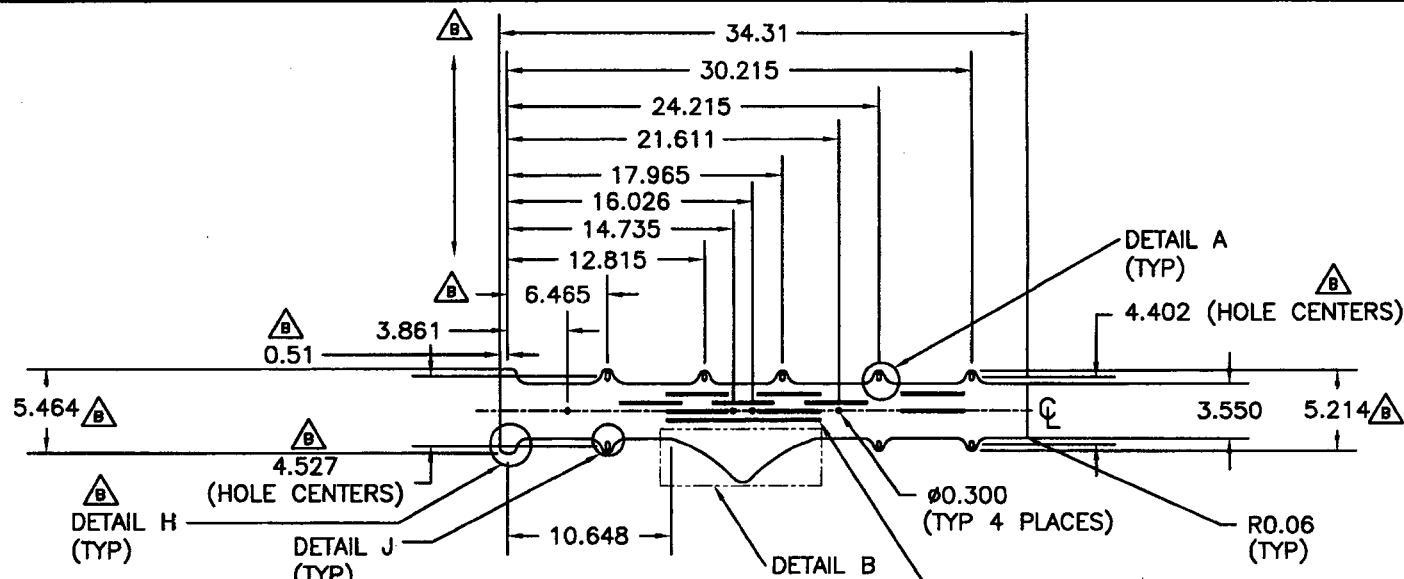
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06 03 20

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	PH	APPROVED	PH	DRAWING NO. D3315
DATE	06.01.31	TITLE	WEARPLATE	REV. B SHEET 2 OF 4
		SCALE	1:16	



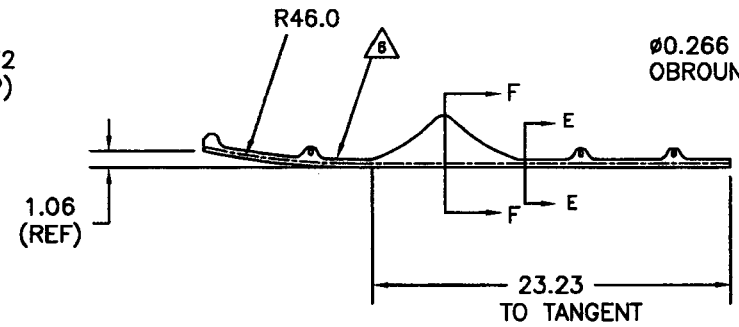
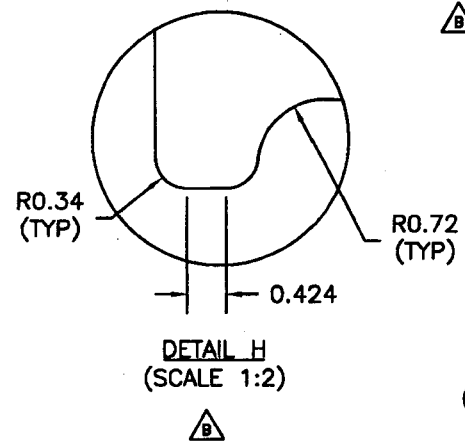
**DART**

060320  
RELEASED

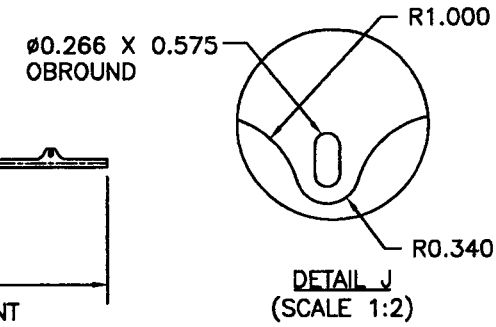


**D3315-5F FLAT PATTERN  
(WELD DETAIL SHOWN)**

APPLY 7560 HARDCOAT WELD  
BEADS PER D3315-5T1 ON BOTTOM SURFACE  
AFTER FORMING (TYP), SEE SECTION E-E



**BENDING DETAIL**



**D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	04	DRAWN BY	04	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		REV. B
DATE	06.01.31	TITLE	D3315	SHEET 3 OF 4
		WEARPLATE		SCALE 1:12

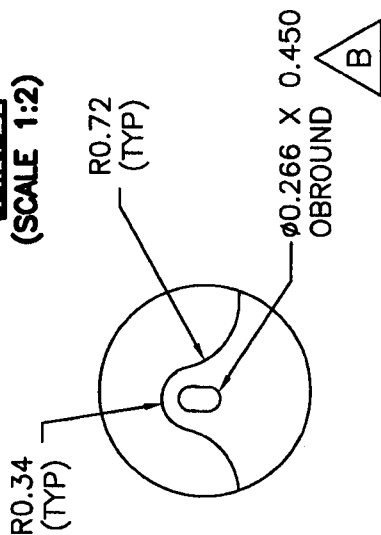
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DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3315	REV. B SHEET 4 OF 4
DATE 06.01.31		TITLE WEARPLATE	SCALE NTS

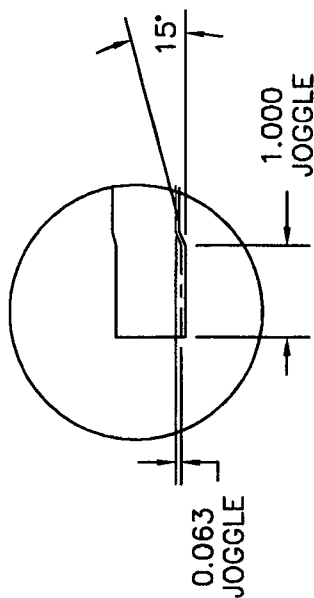
**DETAIL A**  
(SCALE 1:2)



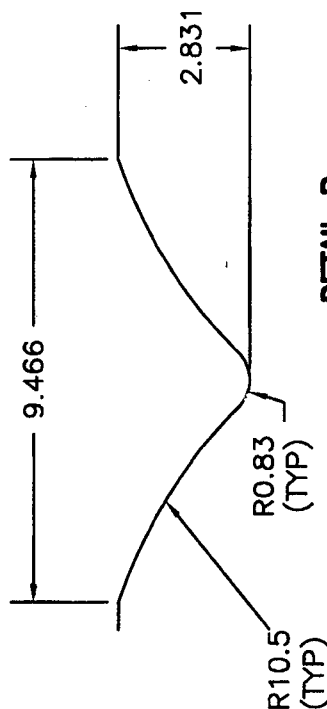
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06.03.20

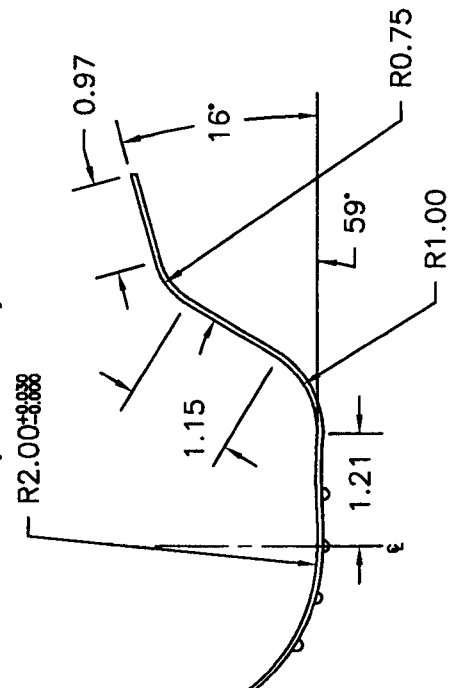
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**DETAIL D**  
(SCALE 1:2)

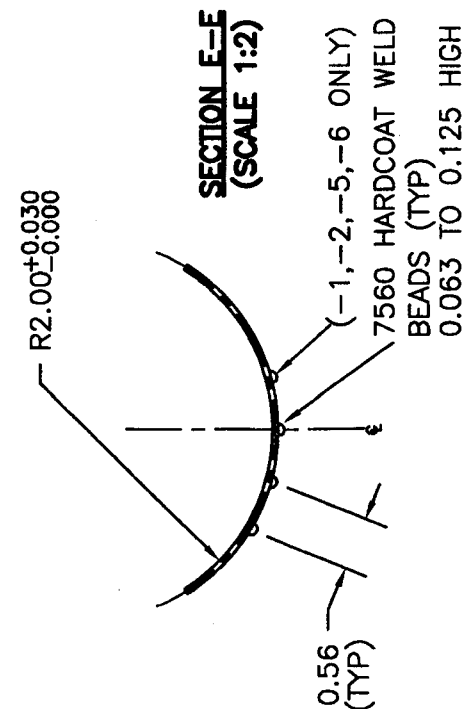


**DETAIL B**  
(SCALE 1:4)



**SECTION F-F**  
(SCALE 1:2)

**SECTION E-E**  
(SCALE 1:2)



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